

PROJECT TITLE : PROCESS ASSURANCE
PERIOD COVERED : JUNE 1 - JULY 31 1981
WRITTEN BY : Bel-T. (THB)

1. AccuRay - Tobacco Weights (1 and 2)

Results of the first 3-month industrial test were presented to the PME Management. The following decisions have been taken:

- a) For the same brand with similar blend, the specified tobacco weight at 12 % should be the same between all production centers concerned.
- b) Each production center should have the possibility of choosing its maximum saving of tobacco, between 0 and 2,5 %.
- c) A limit of - 9 % of the tobacco weight for the reject point was considered too severe. A new trial should therefore be organized with - 9,5 %.

Following this conclusion, we decided to organize a second trial on the brand Marlboro only (MLF-MLK-MLH). The test will involve three production centers: Munich, Weltab, and FTR. Silvertown and Berlin will not be involved in this trial, as they work with a different blend. The trial in Bergen op Zoom will be postponed to the beginning of 1982 because of the start-up of the new primary in the period foreseen.

As the percentage of IS-ES-ET is different depending on the production centers, due to ET introduction, we fixed a density of 267 mg/ml for a Marlboro blend without IS-ES-ET.

All new tobacco weights have been calculated on this basis and sent to the production centers concerned. The lower limit cigarette rod has been fixed at - 9,5 % of the tobacco weight.

At the start of the trial, the lower mean weight limit will be
= 2,5 % for Munich and FTR
= 1,5 % for Weltab.

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2. Non-Tobacco Material (3)

Based on the different trials made in the production centers, the following figures have been adopted as PME standards:

- Quantity of glue on the cigarette seam:
1,5 mg for all cigarette rod lengths.

- Quantity of glue on the tipping paper:
5,0 mg for a tipping length between 17 and 22 mm
7,0 mg " " " " 23 " 28 mm
9,0 mg " " " " 29 " 36 mm.

4. Dilution (4)

Due to the introduction of PDI/DDI values on the cigarette specifications, we fixed the figures to be adopted for brands produced in more than one production center. A range of values will be specified from now on.

14. ETNA (5)

Following the first trial made in Silvertown in January, which did not give very satisfactory results, a second test was organized in June. We found an average of 8,0 ET in the cigarettes (specification: 10 %).

15. Quality Workshop (6 and 7)

The monthly report supplements covering the months April and May have been sent to PME Management and to the QA managers. After a period of action of 3 months, we can say that a good improvement may be particularly noted in the section "packet".

16. MTI Verona and Rovereto (8)

Following our one-week visit to these two factories, the final report has been distributed.

18. Reduction in Tobacco Weights (9)

Due to some incorrect calculations which occurred in some production centers when introducing ETNA, instructions have been issued to all factories to use the right correction factors for improved stems IS, expanded stems ES, and expanded tobacco ET.

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REFERENCES : 1. Standardized tobacco weights and AccuRay limits
Bel-T memo to J.B. Boder (June 1981).

2. Marlboro Standardized Tobacco weights and AccuRay limits, 2nd trial
Bel-T memo to Q.A. Managers (July 1981).

3. Weight of glue on cigarette
Bel-T memo to Q.A. Managers (July 1981).

4. Dilution-US figures on specifications
Bel-T memo to Q.A. Managers (July 1981).

5. Addition of Etna to Marlboro UK blend in PM Silvertown
Bel-T to A. Read (July 1981).

6. Quality Workshop, Monthly Report Supplement (June 1981).

7. Quality Workshop, Monthly Report Supplement (July 1981).

8. Rapport de visite Verona + Rovereto (June 1981).

9. Reduction of Tobacco weights when introducing Expanded Tobacco
Bel-T memo to Q.A. Managers (July 1981).

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